



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4931-5
Job Sheet 169901



Part No: D4931-5

Job Qty: 4 ea

Part Name: Engine Fitting (for B3e models)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/3/18

Job Tracking No:

Due Date: 1/19/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A SHEET 3 IPP REV:A NEW ISSUE 13-09-16 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		1/18/18	0.00	0.00	Start Up Machining-3		<i>W.D. 18/03/04</i>
100	Doosan	4 pcs		1/18/18	0.78	3.48	Doosan		<i>W.D. 18/03/04</i>
110	QC	4 pcs		1/18/18	0.00	0.00	QC2 Machining-3		<i>W.D. 18/03/04</i>
112	Mill Conv	4 pcs		1/19/18	0.00	1.65	Mill Conv 1		<i>J.L.V.</i>
115	QC	4 pcs		1/19/18	0.00	0.00	QC2 Machining-3		<i>J.C.V. 18-03-18</i>
120	QC	4 pcs		1/19/18	0.00	0.00	QC8 Machining-3		<i>W.D. 18/03/27</i>
130	Packaging	4 pcs		1/19/18	0.00	0.00	Packaging3-2	<i>5/127</i>	<i>W.D. 18/03/27</i>
140	QC21-SA	4 Ea		1/19/18	0.00	0.00	QC21		<i>W.D. 18/03/27</i>

Part Op 100 - Machine as per folio FB210

Descriptions: 112 - DRILL HOLES AS PER REQUIRED

21
9-00

MAR 28 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M303R2.000	1	65	0	0

Part Specifications

Specifications could not be found.

Plex 1/3/18 8:59 AM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																				
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																				
Large Fab ☐	Composite ☐	Supplier ☐																					
Date :	Step #:	QTY Effective :				MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition				Completed By																	
						Lead hand / Supervisor Approval Verification																	
						QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																	

DART AEROSPACE LTD		Work Order: 169901
Description: EAPS P2 Engine Fitting		Part Number: D4931-5
Inspection Dwg: D4931	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1-1/16-12 UN 2A	N/A	1-1/16-12 UN 2A	✓		MIP-04	vern
37°	+/-0.5°	37°	✓			
0.185	+/-0.010	0.185	✓			
0.315	+/-0.010	0.313	✓			
0.424	+/-0.010	0.420	✓			
0.250	+/-0.010	0.250	✓			
0.938	+/-0.010	0.934	✓			
1.927 Ref	+/-0.010	1.930	✓			
0.25	+/-0.030	0.253	✓			
0.13	+/-0.030	0.127	✓			
0.907	+/-0.010	0.907	✓			
0.078	+/-0.010	0.076	✓			
Ø0.063	+0.004/-0.001	0.065	✓			
0.13 x 45°	+/-0.030 x +/-0.5°	0.130 x 45°	✓			
0.34	+/-0.030	0.340	✓			
0.25	+/-0.030	0.253	✓			
Ø0.238	+0.005/-0.001	0.240	✓		Caliper	JCL-08
35°	+/-0.5°	35°			MIP-04	vern
0.532	+/-0.010	0.532	✓			
1.063	+/-0.010	1.062	✓		MIP-04	vern
0.513	+/-0.010	0.513	✓		Caliper	JCL-08
0.749	+/-0.010	0.746	✓		MIP-04	vern
1.025	+/-0.010	1.025	✓			

Measured by: MIP/SC-V	Audited by: [Signature]	Preliminary Approval:
Date: 18/02/22 18-03-15	Date: 18/03/22	Date:

Rev	Date	Change	Revised by	Approved
A	14.06.24	New Issue	KJ	[Signature]



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Container No: S047638



Part: D4931-5

Job No: 169901

Serial No/Batch: S047638

Revision:

Inspector:

Date: 03/04/18